STATE OF CALIFORNIA-BUSINESS, TRANSPORTATION AND HOUSING AGENCY ARNOLD SCHWARZENEGGER, Governor

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program
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June 12, 2008

Contract No. 04-0120F4
04-SF-80-13.2 / 13.9
Self-Anchored Suspension Bridge
Letter No. 05.03.01-002151

Michael Flowers
Project Executive
American Bridge/Fluor, A JV
375 Burma Road
Oakland, CA 94607

Dear Michael Flowers,

Submittal 101, Rev. 2 - Fabrication Procedure - T1 Tower Section Mock-Up

The Department has completed review of Submittal ABF-SUB-000101R02, "Fabrication Procedure - T1 Tower Section Mock-Up," dated June 6, 2008. The submittal is "Approved as Noted," as shown on the attachment and as outlined by the following comments

CATEGORY A:

1. In accordance with AWS D1.5-02, the maximum preheat and interpass temperature for welding on Gr485W steel shall be 230C, not 240C.

2. A representative from the Department shall be present to verify preheat temperatures before, during and after the welding.

3. The sketch states, "Cascade and grind terminations or cascade and fill craters complete." Filling the craters complete is a weld technique issue and should occur prior to completing each weld pass (prior to ceasing the arc).

4. **Step 5:** It appears that "Item 9" is a typographical error and should read "Item 3".

CATEGORY C:

1. The Contractor's proposal does not mention the use of different electrodes as discussed in the Tower Fabrication Meeting held May 27th through 30th, 2008 at ZPMC. The Contractor should consider the use of the standard 7018 H4 electrodes in lieu of the higher manganese content 7018-1 electrodes presently specified in WPS-B-T-4113-2, or consider the use of an electrode with higher nickel content.

2. The Contractor's proposal does not consider the use of a PJP weld or a different groove type (i.e. J-groove) as discussed in the Tower Fabrication Meeting held May 27th through 30th, 2008 at ZPMC.

If you have any questions, please contact Mark Woods at 510-385-6897.

Sincerely,

GARY PURSELL
Resident Engineer

Attachment

cc: Rick Morrow
Gary Lai
Mark Woods
file: 05.03.01, 55.0101